



Dart Aerospace Ltd.
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D5738-043
Job Sheet 203348

Accounting Job RD19-1069-01



Part No: D5738-043

Job Qty: 2 pcs

Part Name: MID Wearbar Assembly



Part Weight: 0 lbs

Status: New

Job Created: 11/15/19

Job Tracking No:

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: R+D

Description:

Note: URF 19-1208 DWG D5738 Rev.A IPP Rev. A 19.11.11 New issue DP Verify DD

Ship Via:

POSITIVE RECALL

EFFECTIVE 19/11/19 AUTH NLO

RELEASED 9-89 DATE 19.11.20

Priority: Medium

Bill of Materials**Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier		Sign-off
							Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	2 pcs	11/29/19		0.00	0.08	Large Fab - 1		CZ
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	Automated Welding - B4B	2 pcs	11/29/19		0.00	1.56	Automated Welding - 1 - B4B		ML
120	QC 10	2 pcs	11/29/19		0.00	0.00	QC 10 - 10		CZ
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
							QC 10 - 68		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
11/29/19					0.00	0.00	QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		

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Container No: S234988



Part: D5738-043

Job No: 203348

Serial No/Batch: S234988

Revision: U/R Rev A

Inspector:

Exp Date:

Instructions:

Date: 11/26/19

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				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	KL
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
140	Packaging 3-1 - Stock - B4B	2 pcs	11/29/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
150	QC 21 - SA	2 pcs	11/29/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

POSITIVE
RECALL

DAS

9

9-89

ok to release

DAS

21

9-89

NOV 27 2019

Part Op 100 - (Large Fab) Cut D5738-3 at 69.40" (EXTRA MATERIAL WILL BE CUT ON ASSEMBLY D5738-043)
 Descriptions: 110 - (Automated welding) 1-USE GRINDER TO CHAMFER END AS PER DWG . ***SEE NOTE 8 FOR SURFACE BUILDUP*** USE DT ~~WELDING FIXTURE~~ 8259-M139025
 120 - (QC10- Inspect visual per QSI004- ground welds)
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Identify as per dwg & Stock Location: W/O LOCATION: WA002)
 150 - (QC21- Final Inspection - Work Order Release)

1/15/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304B0.250x0.500	304 Bar .250 X .500	11.6000 ft (5.8 ea)	100-Large Fab - Welded Assy-1	5232085
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	M304B0.250x0.500	12	618	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>2033 48</u> Part No. <u>D5738-043</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date : <u>19.12.11</u>		Sequence #:		QTY Affected :			MRB (QSI042)		
Description Work Order Deviation				Disposition				<u>NO 19.12.11</u>	
weld size is under tolerance dwg 4.3 ± 0.200 is 4.040 4.0 ± 0.200 is 3.50				welds acceptable as is. dwg tolerances will be revised to match achievable manufacturing tolerance				Completed By	
								<u>NO 19.12.11</u>	
								Lead hand / Supervisor	
								QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
				Other/Details:					

